Packaging

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Crosstube Engineering Water Jet Skid-tube Rework Small Fab Prod. Eng. Coor. Quality Machining Scrap Part No. Rec/Store/Packaging Other Thermoforming Finishing Use-as-is **Supplier** Composite Work Order Update Large Fab NCR No. Description of work order update Action Sign & Initial Root Chief Eng Date Verification QC Inspector Description Qty or Non-conformance Date Step Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY** General $\lambda \Omega$ **Landing Gear** Pressure/Forced Ovalized Grain Bend Bending Temperature/Cure Over/Under tolerance BOM/Route Hardware Centre Not Concentric to O/S Weld Part Incorrect Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Part Lost/Missing Instructions Incomplete/Unclear Crushed/Crimped Burrs Maintenance Part Moved Contamination Cuffs

Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Set Up/

0.00

0.00

Run Hours

Tool ID

Tool # Plan

Code

Operation

Description

QC21- Final Inspection - Work Order Release

Memo

Work Center ID

160

Quality Control

160

OC

yut 13-1-17

Number Stamp

Insp.

Reject

Reject

Qty

Accept

Qty

Page 2

NCR:	Yes	/	No

DQA:

Date:

NCR: Yes	s / No				WORK ORDER NON-	CONFO	RMANCE / U	IPDATE	QA Closed:	Date	: :
Work Order:		"			DISPOSITION		EPARTMENT/PROCESS				
Part No					Rework Scrap Use-as-is	Th	Skid-tube Machining ermoforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No)				Work Order Update]	Large Fab	Composite		Supplier	
Root Cause	Date	Step	Qty	l .	iption of work order update or Non-conformance	Initia Chief E	1 5	Action escription	Sign & Date	Verification	QC Inspector
Ooc/Data quip/Tooling Operator Material		Step	Q.,,								
etup Other											
raining Jnapproved											
						FAULT CA	TEGORY				
Landing	Gear Bending			. [General Bend	Gra			Ovalized	F	Pressure/Forced
_	Centre Not Concentric to O/S Cracks			o/s	BOM/Route Broken/Damaged	Insp	dware ection incomplete	 	Over/Under Part Incorre	ct	Temperature/Cure Weld
	Crushed/Crimped Cuffs				Burrs Contamination	Ма	ructions Incomplet intenance	te/Unclear	Part Lost/M Part Moved	_	Wrong Stock Pulled
	Heat Trea	n Strip in	Tube		Countersink Cut Too Short	Mis			Positioned \ Power Loss/		Other
	Ripples in Torque V		Extrusio	n _	Drill Holes Drawing	Offs	et of Calibration				
Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube					Finish Folio	—	Out of Sequence Outside Dimensions				

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Thursday, January 17, 2013 2:30:39 PM

Work Order ID:

96033

Parent Item:

D3121-241

Parent Item Name:

Bearing Assembly

Start Date: 1/17/2013

Required Date: 1/17/2013

Start Qty: 10.00

Required Qty: 10.00

Cap Location ST235 T4 91747 T4 D3121-23 Manufactured No 130 Each 89.0000 1 Bearing	\$3.fo,fi
ST235 74 91747 74 D3121-23 Manufactured No 130 Each 89.0000 1 Bearing	[
91747 74 0 03121-23 Manufactured No 130 Each 89.0000 1 Bearing	. D.()
D3121-23 Manufactured No 130 Each 89.0000 1 Bearing	\mathcal{L}
Bearing Search S	
	0//////////
	700/0/
<u>Loc Qty</u> <u>Loc Code</u>	
ST235 89	
66734 10	
75084 2	
94697 40	
	#

NCR:	Yes	/	No

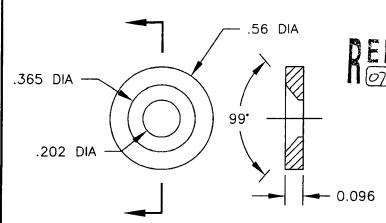
Date:

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:															
Work Orde	ri.					DISPOSITION					AGAINST DEI	PARTMENT	PROCESS		
WOIK OIGE	-					Rework	1		Skid-tube	\neg	Crosstube		Water Jet	\neg	Engineering
Part N	lo.					Scrap	1 1		Machining		Small Fab	Pro	d. Eng. Coor.		Quality
	-					Use-as-is	1	Thern	noforming		Finishing	Rec/Stor	e/Packaging	\Box	Other
NCR N	lo					Work Order Update]		Large Fab		Composite		Supplier		
Root	П	1	!		Descri	ption of work order update		nitial		Act	tion	Sign &		op	
Cause	- 1	Date	Step	Qty		or Non-conformance	1	ief Eng	ı	Desci	ription	Date	Verification	ո	QC Inspector
Doc/Data			•											\Box	
Equip/Tooling								1							
Operator															
Material															
Setup				ŀ											
Other			1												
Process			9											- 1	
Supplier			3												
Training			٠.												
Unapproved			3										L	\Box	
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General						1		_	
		Bending		Age		Bend		Grain	Grain			Ovalized		-	Pressure/Forced
		Centre No	ot Conce	ntřic to	o/s	BOM/Route		Hardwa	are			Over/Under			Temperature/Cure
		Cracks				Broken/Damaged		Inspection Incomplete				Part Incorre		\vdash	Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomp	olete/	Unclear	Part Lost/Mi	ssing	\square	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		L	Part Moved			
		Heat Trea	at			Countersink		Mislabe	eled			Positioned V	- 1		
		Inspectio	n Strip ir	1 Tube	. [Cut Too Short		Misrea	d			Power Loss/	Surge	Ш	Other
		Ripples in	n Bend		, [Drill Holes		Offset							
		Torque W	Vaves in	Extrusio	on 🖫	Drawing		Out of	Calibration						<u></u>
		Turning S	Sequence	2	`.	Finish		Out of	Sequence						
Wave/Twist in Tube						Folio		Outside Dimensions							

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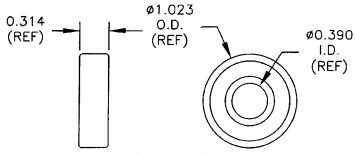


	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
	CHECKED	APPROVED,	DRAWING NO.	REV. E					
	4	 	D3121	SHEET 10 OF 10					
	DATE		TITLE	SCALE					
,	07.11.07		BRACKET ASSEMBLY	1:1					



D3121-17 WASHER (SCALE 2:1)

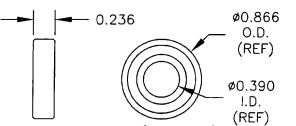
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

*

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
 OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

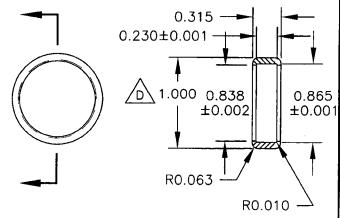
TAP 10-32

UNF-3A

0.050 TO 0.060

0.080

- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

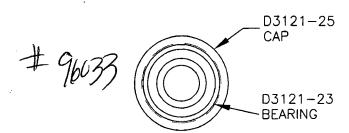


D3121-25 CAP (SCALE 1:1)

1) MATERIAL: DELRIN ROD, Ø1.25

(REF DART SPEC. M-DELRIN-R1.250)

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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				DQA:	Date:	
NCR:	Yes	/ No	WORK ORDER NON-CONFORMANCE / UPDATE			

											Q	A Closed:	Da	te:		
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No						Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other	
NCR No	o					Work Order Update			Large Fab	Composite			Supplier			
Root	Т				Descri	ption of work order update		nitial	Ad	ction		Sign &				
Cause	1	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	n	QC Inspector	
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Other	_						1									
Process	_			1												
Supplier											ŀ					
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	_	Cracks Crushed/Crimped			<u> </u>	Broken/Damaged	\vdash	-	Inspection Incomplete Instructions Incomplete/Unclear		-	art Incorrec		\vdash	Wrong Stock Pulled	
	_		Crimpea		-	Burrs Contamination	-	4	cions incomplete, enance	/Officieal	_	art Lost/Will	33111B		I would stock Lauca	
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 		neat Trea		Tube	-	Cut Too Short	\vdash	Misrea			_	ower Loss/	-		Other	
\ \ \	-	Ripples in	-	rube		Drill Holes	\vdash	Offset	u	L	┙,	2 2000)	0-		1	
F	_	Torque W		Extrusion	, ⊢	Drawing	\vdash	4	Calibration		_					
1	_	Turning S			·	Finish		-1	Sequence		-					
 	_	Wave/Tw				Folio	-	-	e Dimensions		_					
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